

Date: Monday, 12/01/2009 2:38:07 PM  
 User: Julie Dawson

## Process Sheet

<b>Customer</b> : CU-DAR001 Dart Helicopters Services	<b>Drawing Name</b> : AFT LEG ASS'Y
<b>Job Number</b> : 44682	
<b>Estimate Number</b> : 13176	
<b>P.O. Number</b> :	<b>Part Number</b> : D3684049
<b>This Issue</b> : 12/01/2009 <b>S.O. No.</b> :	<b>Drawing Number</b> : D3684 REV B
<b>Prsht Rev.</b> : NC	<b>Project Number</b> : N/A
<b>First Issue</b> : / / <b>Type</b> : MACHINED PARTS	<b>Drawing Revision</b> : B
<b>Previous Run</b> : 38483	<b>Material</b> :
<b>Written By</b> :	<b>Due Date</b> : 23/02/2009
<b>Checked &amp; Approved By</b> : JUD 09.01.13	<b>Qty:</b> 8 Um: Each
<b>Comment</b> : Est Rev:A new issue 08-02-12 DD verified by:JLM Est Rev:B As per Rev B 09-01-07 JLM Verified By:EC	

## Additional Product

Job Number:



<b>Seq. #:</b>	<b>Machine Or Operation:</b>	<b>Description :</b>
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1.0	PACKAGING 1	PACKAGING RESOURCE #1
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Comment: PACKAGING RESOURCE #1

2.0	D36883	STUD
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 10.0000 Each(s) (6)  
 STUD  
 batch 45671 (2) 44824

3.0	D36891	SLEEVE
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 10.0000 Each(s)  
 SLEEVE  
 batch 44825

4.0	D36911	STUD
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 10.0000 Each(s) (7)  
 STUD  
 batch B45485 B46092

5.0	D36921	SPACER
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Comment: Qty.: 4.0000 Each(s)/Unit Total : 40.0000 Each(s)  
 SPACER  
 batch B45672 B44827 7/4/16

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

Date: Monday, 12/01/2009 2:38:07 PM  
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## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: AFT LEG ASS'Y

Job Number: 44682

Part Number: D3684049

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

D36931

Rod End Bearing



Comment: Qty.: 1.0000 Each(s)/Unit Total: 10.0000 Each(s)

Rod End Bearing

batch: 1344828

1345723

SP

7.0

AN3C12A

Bolts



Comment: Qty.: 2.0000 Each(s)/Unit Total: 20.0000 Each(s)

Bolts

batch: M110552

SP

8.0

MS210433

Nut



Comment: Qty.: 2.0000 Each(s)/Unit Total: 20.0000 Each(s)

Nut

batch: M111041

SP

9.0

NAS509L12C

Nuts



Comment: Qty.: 1.0000 Each(s)/Unit Total: 10.0000 Each(s)

Nuts

batch: M106993

SP

10.0

NAS50912C

Nuts



Comment: Qty.: 1.0000 Each(s)/Unit Total: 10.0000 Each(s)

Nuts

batch: M106993

9/4/10

SP

11.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

1-Use anti-seize compound on thread and assemble as per dwg D3684

FF 09-04-22

12.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

Soslar 27 50764722

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D3684-049 PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes (No) DQA: D Date: 09/04/28

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR: <u>44682</u>		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
<u>08.04.24</u>	<u>2</u>	<u>Qty (2) <del>D3693-1</del> 09.04.27</u> <u>STUDS HAVE OVERSIZED</u> <u>HOLE</u>	<u>09.04.24</u> <u>pc</u> <u>OSI 042</u>	<u>SCRAP / REPLACE</u> <u>BACK STUDS D3693-1 (x2)</u> <u>B # 45723 FF</u>	<u>J.O.</u> <u>09/04/29</u>	<u>09/04/27</u>	<u>09.04.24</u> <u>pc</u> <u>OSI 042</u>	<u>02/04/27</u>

NOTE: Date & initial all entries

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## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: AFT LEG ASS'Y

Job Number: 44682

Part Number: D3684049

Job Number:



Seq. #:

Machine Or Operation:

Description :

13.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify with Dart part # using a fine point permanent marker and Stock

Location: Store

9/4/27

SK

SD

14.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

09/04/27

Job Completion



MF  
09-04-27

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

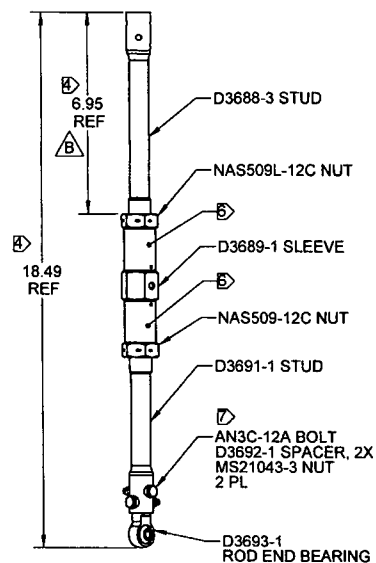
Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

ITEM	QTY -049	PART NUMBER	DESCRIPTION
1	X	D3684-049	AFT LEG ASSEMBLY
2	1	D3688-3	STUD
3	1	D3689-1	SLEEVE
4	1	D3691-1	STUD
5	4	D3692-1	SPACER
6	1	D3693-1	ROD END BEARING
7	2	AN3C-12A	BOLT
8	2	MS21043-3	NUT
9	1	NAS509L-12C	NUT
10	1	NAS509-12C	NUT



**D3684-049 AFT LEG ASSEMBLY**



NO  
WATER  
SUBJECT  
UNCOMMIT  
EN  
RE  
SHIP

**NOTES:**

- 1) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 2) UNITS: INCHES UNLESS OTHERWISE NOTED
- 3) IDENTIFICATION: NONE
- 4) DIMENSION SHOWN IS WHEN D3688-3 & D3691-1 STUDS ARE FULLY THREADED INTO D3689-1 SLEEVE
- 5) WEIGHT: 2.88 lbs
- 6) USE TECTYL 502C CLASS I, MIL-PRF-16173E GRADE 2 OR EQUIVALENT ANTI-SEIZE COMPOUND ON THREAD
- 7) TORQUE FASTENERS TO 20-25 in-lbs

**RELEASED**  
08/12/15

DESIGN	RF	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
DRAWN	RF		
CHECKED	RF	DRAWING NO.	REV. B
MFG. APPR.	RF	D3684	SHEET 5 OF 5
APPROVED	RF	TITLE	SCALE
DE APPR.	RF	TRIPOD MOUNT ASSY	NTS
DATE	08.11.24	COPYRIGHT © 2008 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	